

ABSTRACT OF THE DISCLOSURE

A welded pipe joint having reduced internal stresses comprises a pipe, a socket fitting, and an annular weld. The end surface of the fitting is chamfered, preferably in a concave profile, so that the weld profile subtends an angle of from about 100 degrees to about 120 degrees, rather than the customary 90 degrees. The pipe has no dam or other protuberance to confine the bead of added metal. Prior to welding, the fitting may have an annular lip immediately surrounding the surface of the pipe and may also have a ring spaced from the lip. The ring may be integral with the fitting and spaced from the lip by thin, radially spaced metal bars or may be separate from the fitting.